

54261 DeRen

Work Order ID 53730

November 16, 2009 10:02:23 AM

Page 1

Item ID: DSK078

Accept

Setup Start

Revision ID: A

Stop

Item Name: D2893-1 TURNING DETAIL

Start Date: 11/15/09 Start Qty: 10.00

Cust Item ID:

Required Date: 11/17/09 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081
(4TH AXIS PLUG DT8492)

SL 09/12/04

10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 09/12/04

10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DIP 09/12/04

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53730

November 16, 2009 10:02:24 AM



Page 2

Item ID: DSK078

Accept



Setup Start



Revision ID: A

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 11/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/17/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban ☐ Location:

CNC location

DJP
09/12/09

10

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/09
MF 09-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 16, 2009 10:02:22 AM

Page 1

Work Order ID: 53730



Parent Item: DSK078RevA



Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 11/15/09

Required Date: 11/17/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6104-005RevB		Manufactured	No				Each	0.0000	10.0000			



Round Billet, 17-4

B53706 x10 JL 09/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53730
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.708	2.711	2.708	2.708	2.708
B	4.946	4.966		4.958	4.958	4.959	4.956	4.956
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.726	.726	.725	.725	.725
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.947	2.947	2.946	2.946	2.946
G	2.166	2.186		2.176	2.176	2.177	2.176	2.176
H	3.890	3.910		3.903	3.903	3.902	3.903	3.903
I	0.914	0.934		.926	.925	.925	.925	.925
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.120	.120	.120	.120	.120
L								
M								
N								
O								
P								

Measured by: JL Date: 09/12/03

Audited by: DJT Date: 09/12/03

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53730
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET



First Article



Prototype

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Lathe Section								
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B	4.946	4.966		4.958	4.958	4.959	4.956	4.956
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
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E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.947	2.947	2.946	2.946	2.946
G	2.166	2.186		2.176	2.176	2.177	2.176	2.176
H	3.890	3.910		3.903	3.903	3.902	3.903	3.903
I	0.914	0.934		.926	.925	.925	.925	.925
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.120	.120	.120	.120	.120
L								
M								
N								
O								
P								

Measured by: JL Date: 09/12/03

Audited by: DJA Date: 09/12/04

Prototype Approval: Date:

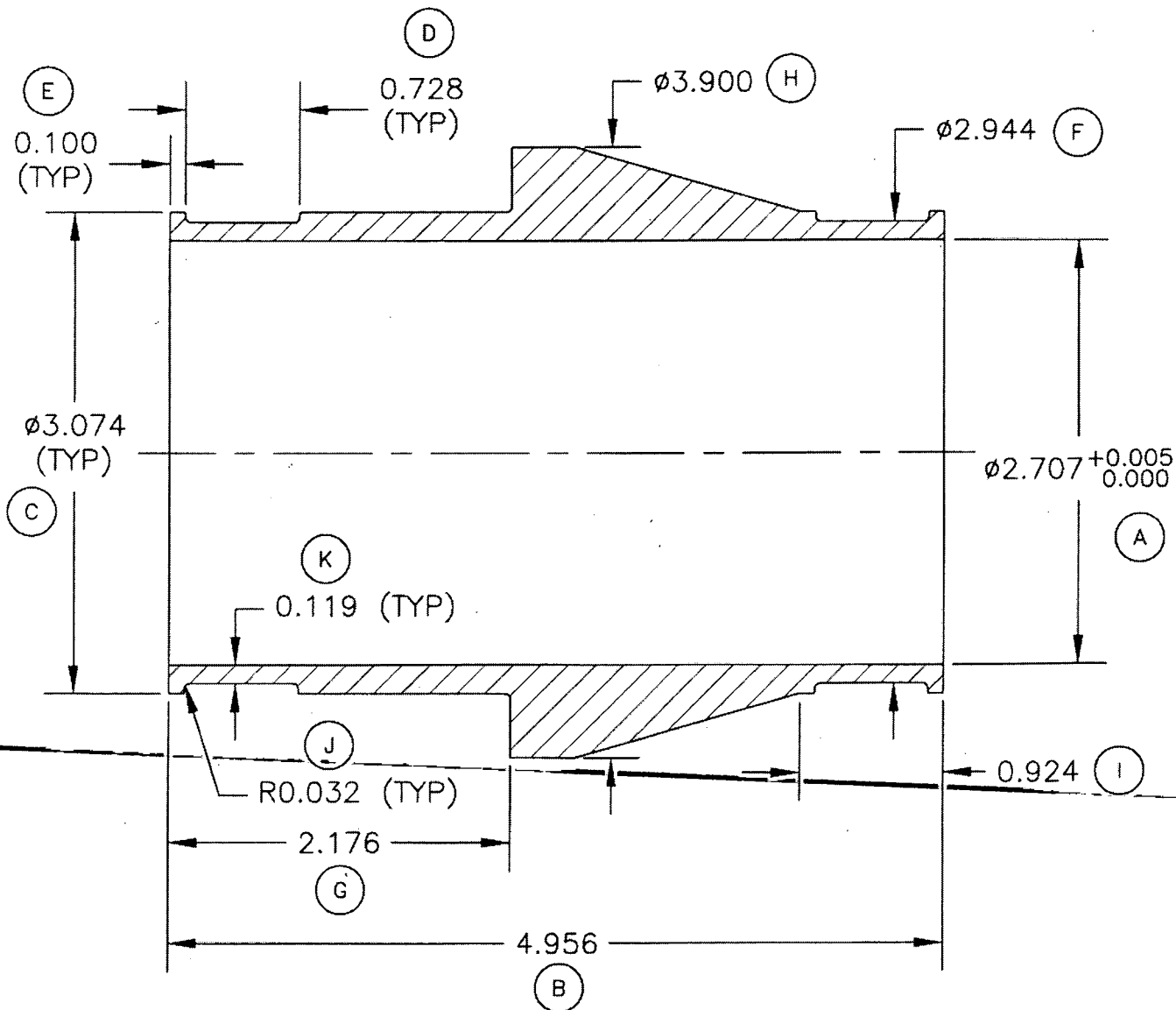
Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

03.07.01

W/O 53730



D2893-1 TURNING DETAIL

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